



FUJUAN GROUP

SHANGHAI FUJUAN GROUP CO., LTD.

PVC EDGEBANDS

Technical Specifications **1/3**

MAJOR APPLICATIONS :

PVC edge bands is a high-quality, thermoplastic edge band based on PVC and synthetic modifiers. It can be processed easily on edge banding machines for covering the edges of carrier materials, mainly chipboards and MDF.

PHYSICAL PROPERTIES :

Shore Hardness D (DIN 53505)	: 76,5 (+/- 3)
Scratch Resistance	: > 1.3 Newton
Light Fastness (DIN 53388)	: > 7 (for indoor applications only)
Gloss Level	: 12 (tolerance +/- 4)
Vicat Softening Temperature	: 81.3 °C (50 N-120 °C /h)
Density (avg.)	: 1,556 kg/m ³
Plasticizer	: 1-4%

Surface & Backside:

Embossing	: Various embossing structures are applied according to customer requirements.
Wood Decors:	: The inks used in production have a minimum light fastness grade of 7. The decor is coated with acrylic UV lacquer for the highest scratch resistance.
Primer	: The backside is primed to suit bonding with all the conventional EVA/PUR Hot melt adhesives.

Tolerances:

<u>Thickness</u>	<u>Tolerance</u>
0.40 – 0.80 mm	+/- 0.05 mm
1.00 – 1.30 mm	+/- 0.10 mm
1.50 – 3.00 mm	+0.05 / -0.20 mm

<u>Width</u>	<u>Tolerance</u>
16 – 23 mm	+/- 0.35 mm
24 – 45 mm	+/- 0.35 mm

INSTRUCTIONS FOR USE :

PVC edge bands can be easily processed with all the conventional hot melt adhesives in the edgebander:

Room and Materials Temperature	: 18-20°C
Chipboard Humidity	: 7-10 %
Application Amount for Adhesive	: 200-250 gr/m ²
Processing Temperature	: 180-220 °C
Feed Rate	: 12-30 m/min



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The above processing parameters are intended to serve as a guideline only. Due to the varying nature of carrier materials and hot melt adhesive, we advise the customer to carry out his own trials to optimize individual working parameters.

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PVC EDGEBANDS

Technical Specifications **2/3**

PACKAGING INFORMATION:

Thin Edges: (0.40 or 0.45 mm thickness)

Type of Core	:	Paper inner core
Inner Core Diameter	:	80 - 82 mm
Outside Roll Diameter	:	36 or 38 mm
Roll Label	:	On the edgeband
Length / Roll	:	<u>Thickness</u> <u>Length</u> 0.40 mm 200 m 0.45 mm 200 m
Length Tolerance	:	(All production batches include 15% non-uniform lengths) (+/-) 1%
Joints	:	Minimal – marked with a red tape
Packaging	:	Packed in white printed boxes
Box Size	:	385 x 385 x 250 mm (LxWxH)
Rolls / Box	:	10 rolls for 22 mm,
Box Weight	:	29 kgs average
Labeling	:	Customer code and description on all box labels

Thick Edges: (1.00, 2.00 & 3.00 mm thickness)

Type of Core	:	None
Inside Roll Diameter	:	20 or 23 mm
Outside Roll Diameter	:	55 or 68 mm
Roll Label	:	On the edgeband
Length / Roll	:	<u>Thickness</u> <u>Length</u> 1.00 mm 200 m 2.00 mm 100 m 3.00 mm 100 m
Length Tolerance	:	(+/-) 1%
Joints	:	None
Packaging	:	Packed in white printed boxes
Box Size	:	565 x 565 x 120 mm (LxWxH)
Rolls / Box	:	5 rolls for 22 mm, 4 rolls for 29 mm, 3 rolls for 35 mm etc.
Box Weight	:	36 kg average
Labeling	:	Customer code and description on all box labels



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SHANGHAI FUJUAN GROUP CO., LTD.

PVC EDGEBANDS

Technical Specifications **3/3**

HAZARDS INFORMATION:

PVC edge bands do not contain any materials hazardous to health that can be emitted during processing or storage. The material is suitable for recycling; it is not suitable for incineration.

STORAGE:

PVC edge bands should not be stored under direct sunlight or in extreme temperatures. Avoiding these extreme conditions, the edge can be stored for a long time with no change to its properties. However, it is important that the material should rest for at least one day at room temperature prior to processing.

All the information in this technical datasheet is given in good faith and is the result of our own experience and tests and can only be considered as a guideline for operation.

We guarantee the constant quality of our products but we cannot be held responsible for the results obtained in their use, since the conditions of work are beyond our control. We recommend that tests should be made to determine the suitability of the product for a specific purpose before the production is started.

In spite of the very good resistance to diverse chemicals, the sustained action of various vapors (cigarette smoke, kitchen fumes, etc.) may result in the discoloration of the top lacquer. These discoloration effects are beyond our control and are the result of expected wearing of the product over time.